

Date: Wednesday, 5/23/2007 3:43:28 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE, OUTBOARD, LH, 206
 Job Number : 32505
 Estimate Number : 10818
 P.O. Number : N/A Part Number : D26651
 This Issue : 5/23/2007 S.O. No. : N/A Drawing Number : D2665 REV.D
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : D
 Previous Run : 29748 Material : N/A
 Due Date : 6/10/2007 Qty: 12 Um: Each
 Written By :
 Checked & Approved By : 7/07.05.24
 Comment : Est: C 00.11.01 Removed P/O for Powder Coat - in house
 processEC
 Est Rev:D As per Rev D 07-03-19 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D6101003

7075-T7351 2X6.25X7.875



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

7075-T7351 2X6.25X7.875

Cut Size 2.0" x 6.25" x 7.88"

Grain Along Long 7.88 Length

Batch no 33792

→ 24 blanks taken in inventory?
 0 blanks allocated?

SK 07.09.12 (12)

2.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program batch number.

1-Inspect part number and batch number are programmed correctly.

3-Fixturing Inspection last completed on NA by NA

4-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet

5-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet

6-Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet

7- Deburr

SK 07.09.12 (12)

3.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

SK 07.09.12 (12)

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SK 07.09.12 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 07/09/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/23/2007 3:43:28 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, OUTBOARD, LH, 206

Job Number: 32505

Part Number: D26651

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

ml 07/09/12

(12)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M. 12/13 07/09/13

(12x)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

ML 07-09-13

(12)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

7/9/13 SD

(12x)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7/9/13 SD

(12x)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

7/9/13/14

(12)

Job Completion



U 8/10/14

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	32505
Description: 206 Saddle, Outboard, Left side	Part Number:	D2665-1
Inspection Dwg: D2665 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. D and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.125	.124	.124	.124		
B	0.100	0.140		.130	.130	.130	.132		
C	1.125	1.145		1.135	1.135	1.137	1.137		
D	0.615	0.685		.665	.665	.665	.665		
E	0.240	0.260		.255	.255	.255	.255		
F	1.313	1.343		1.327	1.327	1.327	1.327		
G	0.210	0.230		.224	.224	.224	.224		
H	0.100	0.180		.137	.137	.137	.137		
I	2.470	2.510		2.496	2.496	2.496	2.496		
J	1.565	1.585		1.568	1.568	1.568	1.568		
K	0.235	0.240		.238	.238	.238	.238		
L	0.100	0.120		.110	.118	.118	.118		
M	0.990	1.010		1.008	1.005	1.005	1.005		
N	0.510	0.515		.510	.510	.510	.510		
O	5.990	6.010		6.001	6.001	6.001	6.001		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.314	.314	.314	.314		
S	0.315	0.322		.319	.319	.319	.319		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		.802	.801	.801	.801		
W	0.540	0.560		.550	.551	.551	.551		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.259	.259	.259	.259		
Z	0.912	0.932		.925	.920	.920	.920		
AA	0.490	0.510		.503	.503	.503	.503		
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	SG
Date:	07.09.06

Audited by:	MD
Date:	07/09/12

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART AEROSPACE LTD	Work Order:	32505
Description: 206 Saddle, Outboard, Left side	Part Number:	D2665-1
Inspection Dwg: D2665 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. D and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	15	26	37	48		
A	0.100	0.140		.125	.125	.120	.120		
B	0.100	0.140		.130	.130	.126	.126		
C	1.125	1.145		1.135	1.135	1.135	1.135		
D	0.615	0.685		.665	.665	.665	.665		
E	0.240	0.260		.255	.255	.255	.255		
F	1.313	1.343		1.327	1.327	1.327	1.327		
G	0.210	0.230		.224	.224	.224	.224		
H	0.100	0.180		.137	.137	.137	.137		
I	2.470	2.510		2.496	2.496	2.496	2.496		
J	1.565	1.585		1.568	1.568	1.568	1.568		
K	0.235	0.240		.239	.239	.239	.239		
L	0.100	0.120		.110	.110	.110	.110		
M	0.990	1.010		1.006	1.006	1.006	1.006		
N	0.510	0.515		.510	.510	.510	.510		
O	5.990	6.010		6.003	6.003	6.003	6.003		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.314	.314	.314	.314		
S	0.315	0.322		.319	.319	.319	.319		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		.801	.801	.801	.801		
W	0.540	0.560		.551	.551	.551	.551		
X	1.674	1.684		.679	.679	.679	.679		
Y	0.257	0.262		.259	.259	.259	.259		
Z	0.912	0.932		.920	.920	.920	.920		
AA	0.490	0.510		.503	.503	.503	.503		
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	SG
Date:	07/09/12

Audited by:	and
Date:	07/09/12

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART AEROSPACE LTD	Work Order:	32505
Description: 206 Saddle, Outboard, Left side	Part Number:	D2665-1
Inspection Dwg: D2665 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. D and record below:

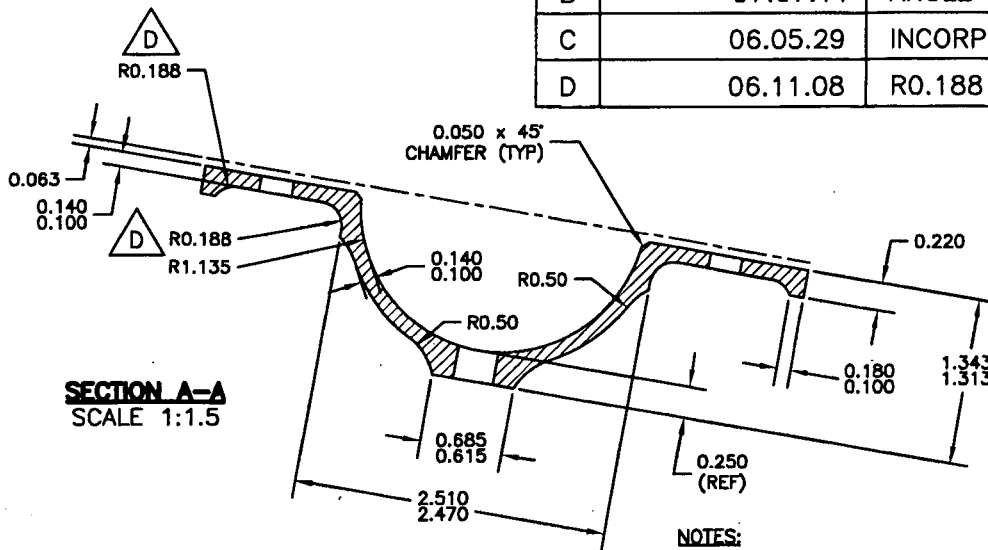
				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1 _a	2 ₁₀	3 ₁₁	4 ₁₂		
A	0.100	0.140		.122	.122	.122	.122		
B	0.100	0.140		.127	.127	.127	.127		
C	1.125	1.145		1.135	1.135	1.135	1.135		
D	0.615	0.685		.660	.660	.660	.660		
E	0.240	0.260		.252	.252	.252	.252		
F	1.313	1.343		1.325	1.325	1.325	1.325		
G	0.210	0.230		.221	.221	.221	.221		
H	0.100	0.180		.140	.140	.140	.140		
I	2.470	2.510		2.495	2.495	2.495	2.495		
J	1.565	1.585		1.575	1.575	1.575	1.575		
K	0.235	0.240		.239	.239	.239	.239		
L	0.100	0.120		.110	.110	.110	.110		
M	0.990	1.010		1.006	1.006	1.006	1.006		
N	0.510	0.515		.510	.510	.510	.510		
O	5.990	6.010		6.003	6.003	6.003	6.003		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.314	.314	.314	.314		
S	0.315	0.322		.319	.319	.319	.319		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.363	1.363		
V	0.787	0.807		.800	.800	.800	.800		
W	0.540	0.560		.550	.550	.550	.550		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.258	.258	.258	.258		
Z	0.912	0.932		.924	.924	.924	.924		
AA	0.490	0.510							
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <i>SR</i>	Audited by: <i>ML</i>
Date: 07.09.06	Date: 07/09/12

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART

DESIGN #	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED #	DRAWING NO. D2665	REV. D SHEET 1 OF 1
DATE 06.11.08	TITLE SADDLE FWD OUTSIDE HIGH	SCALE 1:3	
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	

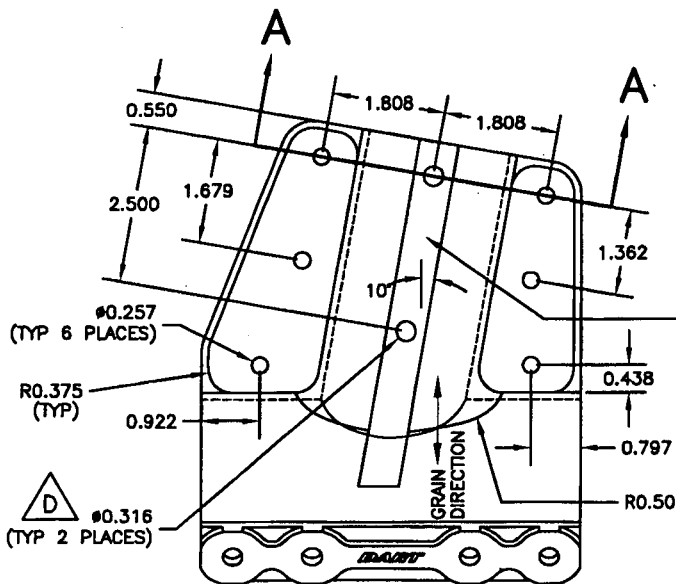


RELEASED

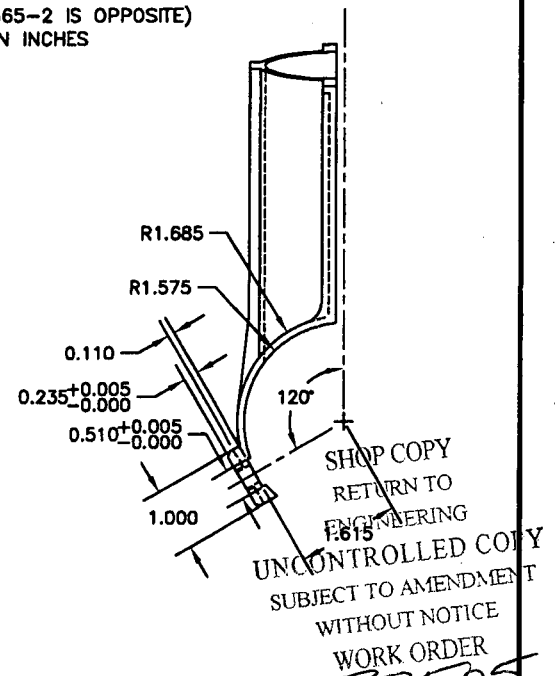
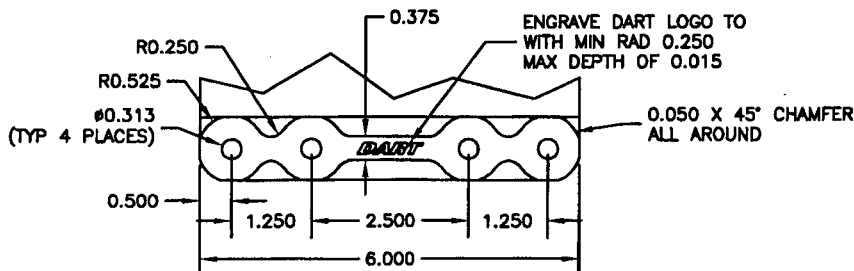
07.02.12 #

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2665-1 SHOWN (D2665-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



ENGRAVE PART
NUMBER AND
BATCH NUMBER
TO MAX DEPTH
OF 0.010 WITH
MIN RADIUS
OF 0.010

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